

AIR BAG TETHER CONSTRUCTION**CROSS-REFERENCE TO RELATED APPLICATIONS**

Sub A³
This application is a divisional of co-pending U.S. Patent application 09/549,284, filed April 14, 2000, which is herein entirely incorporated by reference.

TECHNICAL FIELD

10 The present invention relates to air bag tethers and to a pattern-wise arrangement of such tethers in relation to air bag panels on a fabric blank, thus resulting in increased fabric utilization and an overall cost savings per finished air bag. The air bag tether system of the present invention is comprised of two congruent tether panels that are joined to one another and to a respective air bag panel. In a preferred embodiment, the tether panel that is attached to the face panel of the air bag is cut in alignment with the warp and the fill of the fabric blank, while the rear tether panel (which is attached to the rear panel of the air bag) is cut on the bias with respect to the warp and the fill of the fabric blank. This two-piece construction, with one bias-cut piece, decreases the amount of fabric that is used in the manufacture of the air bag and tethers, while providing sufficient elongation for the tether system to be functional.

BACKGROUND

20 Traditionally, air bag tethers have been used to control the excursion of an air bag as it inflates. As gas is released, causing the air bag to rapidly inflate, it is necessary to keep such inflation from occurring in an uncontrolled manner. Tethers, which are sewn to the face and rear panels of an air bag, keep the inflating air bag from expanding so rapidly as to adversely affect the safety of the vehicle occupant, as the vehicle occupant contacts the air bag.

5 Tethers are conventionally strip-shaped pieces of fabric that are aligned in pattern-wise arrangement on a fabric blank, or are aligned in relation to air bag panels that may be cut from the same blank. The patterns for these tethers may include a circular portion in the center area of the tether strip around which the strip is attached to the air bag panel. It is understood that such tethers should have a capacity for elongation (that is, the tethers should be able to stretch to accommodate the rapid excursion of the bag). For this reason, conventional tethers have been cut on the bias with respect to the warp and fill of the fabric. However, aligning the tether patterns to fulfill this condition increases the amount of fabric needed to create an appropriate number of tethers for a plurality of air bags. Furthermore, because fabric utilization comprises more than fifty percent of the costs of a finished air bag, aligning the tethers in this manner increases production costs.

SUMMARY

15 The present invention addresses the problems of fabric utilization and tether elongation. By understanding that the portions of the tether that are connected to the rear panel typically experience a greater level of stretch than the tether portions connected to the face panel, a fabric-saving solution was created. Instead of the entire tether length being cut on the bias, only that portion of the tether attached to the rear panel is cut on the bias. Using a two-
20 piece tether system in which only the rear tether panel is cut on the bias increases fabric utilization by allowing these bias-cut tether portions to be arranged around air bag panels into spaces which otherwise be considered fabric waste. The portion of the tether that is attached to the face panel is cut in alignment with the warp and fill of the fabric. The combination of the bias-cut and alignment-cut tether portions leads to an improved fabric
25 utilization, while providing a tether system that is capable of sustaining the forces exerted by the inflating air bag.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1A shows an overhead, or plan, view of a rear air bag panel as might be used in the formation of an air bag;

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Fig. 1B shows a plan view of a bias-cut tether panel of the present invention, as would preferably be attached to the rear air bag panel of **Fig. 1A**;

Fig. 1C shows a plan view of a front air bag panel as might be used with the air bag panel of **Fig. 1A** to form an air bag;

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Fig. 1D shows a plan view of a tether panel of the present invention that is cut in alignment with the warp and fill of a fabric blank, as would be attached to the air bag panel of **Fig. 1C**;

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Fig. 1E shows a plan view of a circular reinforcement as might be used with the tether panel of **Figs. 1B** or **1D**;

Fig. 2A shows a plan view of the rear air bag panel of **Fig. 1A**, to which the tether panel of **Fig. 1B** and the circular reinforcement of **Fig. 1E** have been attached;

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Fig. 2B shows a plan view of the front air bag panel of **Fig. 1C**, to which the tether panel of **Fig. 1D** and the circular reinforcement of **Fig. 1E** have been attached;

Fig. 3A shows a plan view of the front of a completed air bag, using the air bag panels of **Figs. 1A** and **1C**;

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Fig. 3B shows a side view of the completed air bag of **Fig. 3A**;

Fig. 3C shows a cross-sectional view of the air bag of **Fig. 3A**, as taken along line 3-3, and further shows the lapped relation of the tether panels of **Figs. 1B** and **1D**;

Fig. 4 shows a plan view of the arrangement of the air bag components of **Figs. 1A, 1B, 1C, 1D, and 1E** on a fabric blank, in accordance with the teachings herein; and

Fig. 5 shows a plan view of the arrangement of conventional air bag panels and tethers, in accordance with the teachings of the prior art.

DETAILED DESCRIPTION

In order to describe the invention, it is necessary that certain terms be defined. The term "bias" is intended to refer to a line cut diagonally across the weave of a fabric, typically at an angle of 45 degrees with respect to the warp and fill. The term "front" shall refer to that portion of an air bag that is nearest a vehicle occupant, while the term "rear" shall refer to those portions of an air bag that are furthest from the vehicle occupant (e.g., in the case of front-seat air bags, nearest the windshield). The term "tether" shall refer to a strip-shaped piece of fabric utilized to prevent the uncontrolled excursion of an inflating air bag from adversely affecting a vehicle occupant with whom such a bag comes into contact. The term "tether system" shall refer to a functional tether comprised of two or more joined tether panels, as in the case of the present invention.

Because of the speed with which an air bag inflates, it is necessary, for the protection of vehicle occupants, to control the volume of space that the air bag occupies in the vehicle cabin. Tethers accomplish this task by preventing the uncontrolled expansion of the air bag.

Tethers are securely connected to the interior portions of the air bag, usually by sewing or other joining techniques.

Fig. 1A shows a rear air bag panel **6** that could be used in the creation of an air bag **10** (see also **Fig. 3B**). Panel **6** has the shape of a six-sided polygon for the purposes of discussion, but panels having other geometries, including those with straight or curved sides, could also be used as design specifications dictate. The positions of vent holes **7** may also be modified to meet design specifications.

Fig. 1B shows a bias-cut tether panel **16** that is suitable for attachment to rear bag panel **6**, in accordance with the teachings herein. Tether panel **16** is substantially rectangular in shape, with slight truncation along each area where the right angles that form corners would otherwise be located. As stated above, it has been found that the portion of a tether that is connected to the rear of the air bag experiences the greatest stress and, as a result, needs the capacity to stretch to accommodate such stress. Tether panel **16** is capable of stretching to accommodate such stress, because tether panel **16** is cut on the bias of the fabric.

Fig. 1C shows a front air bag panel **4** that could be used in the creation of air bag **10** (see also **Fig. 3B**). Panel **4** has the shape of a six-sided polygon for the purposes of discussion, but panels having other geometries, including those with straight or curved sides, could also be used as design specifications dictate. It has been found that congruent panels having a like size and shape are most useful in creating air bag **10** (shown in **Figs. 3A** and **3B**).

Fig. 1D shows a tether panel **14** that is suitable for attachment to front bag panel **4**, in accordance with the teachings herein. Unlike tether panel **16**, tether panel **14** is cut in alignment with the warp and the fill of the fabric. As a result, tether panel **14** is less capable of elongation than tether panel **16**. However, this elongation difference has not been found to be problematic. Tether panel **16** contributes the majority of the elongation that is necessary for the entire tether system, and the fabric that is saved by utilizing such a multi-piece tether system reduces production costs significantly. In a preferred embodiment, tether panel **14** is attached to bag panel **4** and bias-cut tether panel **16** is attached to bag panel **6**. It is believed, however, that circumstances might arise in which it would be preferable for bias-cut tether panel **16** to be attached to bag panel **4**.

It is common for reinforcements, having a circular or other shape, to be used in the production of air bags **10**. Circular reinforcements **12**, shown in **Fig. 1E**, are superimposed on tether panels **14**, **16** in a central location. Such reinforcements **12** are particularly important in preventing tears around the mouth of air bag **10**, at the location of the inflation media. The position of tether panel **16** and reinforcements **12** on bag panel **6** is shown in **Fig. 2A**. The circular area provided by seam **11** creates an identifiable area at which air bag **10** may be positioned with relation to the inflator. An opening for the inflator is then cut in tether panel **16**, inside the perimeter defined by seam **11**. Often, more than one reinforcement **12** is used with rear tether panel **16** on bag panel **6**. The number of reinforcements **12** may vary from zero to five, with a preferred number being at least two, and a more preferred number being three.

Front bag panel **4** typically has one circular reinforcement **12** that is placed over front tether panel **14**, but other numbers of reinforcements **12** may be used as desired. Both tether panel **14** and reinforcement **12** are attached to bag panel **4** by sewing seam **11** around the

circumference of reinforcement 12. The relative positions of tether panel 14 and reinforcement 12 are shown in Fig. 2B. The circular area that is created by seaming around reinforcement 12 produces a slightly recessed area in the center region of air bag 10 when inflated, which provides a suitable surface for contact by a vehicle occupant.

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Fig. 3A shows inflated air bag 10, as viewed from the vehicle occupant. Circular seam 11 is in the center portion of air bag 10, seam 11 sewn around reinforcement 12 (as previously described) to produce a slightly recessed area on front bag panel 4 of air bag 10. Fig. 3B is a side view of air bag 10, indicating the relative positions of front bag panel 4 and rear bag panel 6. Fig. 3C is a cross-sectional view of air bag 10, as taken along line 3-3 of Fig. 3A. In order to produce a functional tether system, tether panels 14, 16 must be joined to one another. Tether panels 14, 16 are shown in lapped fashion in the interior of air bag 10. The joining of tether panels 14, 16 is shown as being achieved by means of rectangular seam 18, but such joining may be accomplished by any other means, such as welding or other seaming techniques. Air bag 10 is finished by sewing, or otherwise securing, panels 4, 6 along their coincident perimeter portions.

The layout of bag panels 4, 6, tether panels 14, 16, and reinforcements 12 on fabric blank 30 is shown in Fig. 4. Vent reinforcements 9, which support the fabric surrounding vent holes 7 on rear bag panel 6, are also incorporated into the pattern-wise configuration of air bag components. It has been found that utilizing panels 4, 6 having straight edges allows for greater flexibility in the arrangement of components and an overall reduction in the amount of fabric not utilized in functional components. By way of example only, and not as a limitation, panels 4, 6 having six sides are illustrated. The separation of the conventional tether into two tether panels 14, 16 allows a greater number of air bag components to be

produced from a smaller length of fabric, by nesting tether panels **14, 16** between bag panels **4, 6** into areas that would otherwise be considered fabric waste.

Fig. 5 shows a plan view of conventional one-piece tethers **20** as arranged on a fabric blank **32** with conventional circular panels **24, 26**. Reinforcements **22, 28, 29** on fabric blank **32** are also shown. Because tethers **20** are formed in accordance with the thinking that the entirety of tethers **20** must be cut on the bias, the amount of fabric blank **32** that must be used to create tethers **20** is considerably more than for the two-piece tether system of the present invention.

Conventional air bag panels **24, 26** often feature non-linear sides or irregular geometries, making it difficult to position tethers **20** on a bias between such panels **24, 26**. Therefore, to arrange a plurality of such tethers **20** on a fabric blank **32** requires grouping tethers **20** in one area of blank **32** and cutting each tether **20** on a bias. The requirement that each tether **20** be cut on the bias (in order to achieve the desired elongation) results in an increased amount of fabric utilized per finished air bag **10** and an increased amount of fabric waste.

The multi-piece tether system includes a tether panel **14** that is cut in alignment with the warp and fill of fabric blank **30** and a tether panel **15** that is cut on the bias with respect to the warp and fill of fabric blank **30**. By incorporating this multi-piece tether system, the present invention addresses the issues of fabric utilization and tether elongation, thus representing a useful advancement over the prior art.